

Work Order ID 121525 - 1

121525

Page 1

Thursday, June 26, 2014 3:02:22 PM

Item ID: D4636-5

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 7/18/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/18/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 14-06-27

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4636

D

100

100

Waterjet

FLOW CNC Waterjet

6061.040"

FLOW WATER JET

Memo

1-Cut as per Dwg

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

0.00

0.00

DAS

46

9-89

(128) / v 14/07/14

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

DAS

46

9-89

(128) / v 14/07/14

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

DAS

38

9-89

(128) / v 14/08/14

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Hand Finishing

(30)

DAS
38
9-89

14/02/20

14/08/15

30

7/6, 148-18

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Item ID: D4636-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 7/18/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/18/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

30 ϕ 14-8-18. DAS 34 9-89

170

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

170

Powdercoat

Memo

0.00

Powder Coating

START TIME: 12:55

OVEN TEMPERATURE: 500

FINISH TIME: 1:25

30 ϕ 14-8-18. DAS 34 9-89

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

30 ϕ (2P) 14/08/18.

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[illegible]

Picklist Print

Wednesday, July 09, 2014 11:28:36 AM

Page 1

Work Order ID: 121525

121525

Parent Item: D4636-5

D4636-5

Parent Item Name: Bracket

Start Date: 7/18/14

Required Date: 7/18/14

Start Qty: 120.00

Required Qty: 120.00

Comments:

IPP REV:A 12.04.30 NEW ISSUE DD VERF:EC
13.07.17 AS PER DWG REV.C DD VERF:JLM

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040

Purchased

No

100

sf

127.7900

0.01

2

OK 14/09/14

M6061T6S 040

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

127.79

m128422

49.79

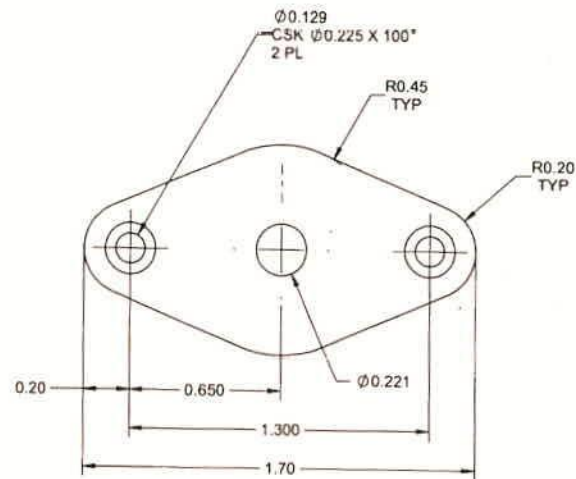
m129584

78

B127881

20

DAS
46
9-89



D4636-5 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.00 lbs

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 121525 ML5
1406-27

RELEASED
2013-12-23
ADS

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PC	DRAWING NO. D4636	REV. D
MFG. APPR.	BS	SHEET 4 OF 7	
APPROVED	BS	TITLE	SCALE
DE APPR.	BS	BRACKET ASSEMBLY	
DATE	13.12.09	NTS	

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